

Claims:

1. A method for drawing a strip initially cast by means of a twin roll strip casting apparatus, comprising:
- 5 a roll gap maintenance step where roll gap is maintained so that a leader strip having a length l_0 disposed above a roll nip does not fall between rolls;
 - a casting initiation step where a stopper is disengaged from a tundish hole of a tundish so that molten metal is poured into a space between the rolls, and the rolls are rotated at the same speed as an initial starting speed v_0 of each of the rolls if the position of the stopper is higher than the actually poured position of the molten metal (rod_offset);
 - 10 a casting speed acceleration step where a roll repulsive force (rolling force) is detected when the molten metal is solidified to the leader strip and passes between the rolls, and the casting speed is accelerated if the roll repulsive force reaches a load threshold; and
 - 15 a normal control step where the casting speed is detected, and if the casting speed reaches a target value, i.e., a normal casting speed, the casting speed is maintained at the normal casting speed.
2. The method as set forth in claim 1, wherein the length l_0 of the leader strip is set to complete the initial solidification before the leader strip completely passes through the roll nip.
- 20 3. The method as set forth in claim 1, wherein the casting speed acceleration step comprises a rolling force control step where the rolling force is controlled if the roll repulsive force (rolling force) reaches the load threshold.
- 25 4. The method as set forth in claim 1, wherein the initial starting speed v_0 is previously set to satisfy the following equation: $v_0 = l_0 / \Delta t$ (Δt : the time period from the time where the casting process is initiated to the time where the roll repulsive force reaches the load threshold).